

CLAIM AMENDMENTS

1-8. (Canceled)

9. (Currently amended) A method of making a socket on a pipe made of copper, steel or alloys of Cu, Ni and Fe, by an at least single-step expansion of a pipe end with a large jump in diameter, comprising:

introducing an expansion tool axially into the pipe end, and

~~at least partially upsetting~~ expanding a region of the pipe end to provide
an expanded region ~~or a region to be expanded~~ of the pipe end ~~simultaneously~~
with ~~and/or subsequently to~~ an enlarged wall thickness no earlier than
introduction of the expansion tool into the pipe end by a force applied axially to
the pipe end while limiting an outer diameter of the pipe end to be processed by
way of an upsetting device and at least one shaping shoe at least partially
surrounding the pipe end.

10. (Currently amended) The method as defined in claim 9, ~~wherein, in~~
~~case of~~ wherein the pipe end has a multi-step expansion, and ~~of the pipe end,~~
only the ~~region of the pipe end to be expanded or the~~ expanded region of the pipe
end of largest diameter is upset.

11. (Currently amended) The method as defined in claim 9, wherein the
~~region of the pipe end to be expanded or the~~ expanded region of the pipe end is
upset to such an extent that the wall thickness thereof is increased ~~in the upset~~

~~portion up to the wall thickness of the rest of the pipe or at least up to the wall thickness of the previously expanded portion.~~

12. (Currently amended) The method as defined in claim 9, wherein the ~~upset pipe ends are~~ end is inwardly flanged for receiving sealing elements.

13. (Currently amended) The method as defined in claim 10, wherein the ~~region of the pipe end to be expanded or the expanded region of the pipe end is upset to such an extent that the wall thickness thereof is increased in the upset portion up to the wall thickness of the rest of the pipe or at least up to the wall thickness of the previously expanded portion.~~

14. (Currently amended) The method as defined in claim 10, wherein the ~~upset pipe ends are~~ end is inwardly flanged for receiving sealing elements.

15. (Currently amended) The method as defined in claim 11, wherein the ~~upset pipe ends are~~ end is inwardly flanged for receiving sealing elements.

16. (Currently amended) An apparatus for making a socket on a pipe end having an expanded region with an enlarged wall thickness, comprising:

an expansion tool which is axially introducible into the pipe end and which has one or more conical and cylindrical parts adapted to determine a subsequent inner diameter of the pipe end,

at least one shaping shoe having conical and cylindrical parts adapted to determine a subsequent outer diameter of the pipe end, and

a substantially cylindrically structured upsetting device having a smallest inner diameter which corresponds, with necessary play, to a maximum outer diameter of the expansion tool and a substantially radially extending annular shoulder which is pressable axially against an end face of the pipe end during an upsetting step to produce said expanded region of said pipe end with said enlarged wall thickness.

17. (Currently amended) The apparatus as defined in claim 16, wherein, on its side oriented toward the pipe end, the expansion tool has a cylindrical part which adjoins the shoulder, ~~and having~~ at least one of the upsetting device and the shaping shoe has an inner diameter which determines the greatest diameter of that enlarged outer diameter of a cylindrical part of the pipe end which is reached after the upsetting step.

18. (Currently amended) The apparatus as defined in claim 17, wherein the ~~inner~~ diameter of the cylindrical part of the expansion tool corresponds to a maximum inner diameter of the at least one shaping shoe.

19. (Currently amended) The apparatus as defined in claim 17, wherein an axial length of the expansion tool cylindrical part is ~~greater~~ no less than or equal to a length of a cylindrical part of a said shaping shoe, ~~which has a largest inner diameter.~~

20. (Currently amended) The apparatus as defined in claim ~~15~~ 18, wherein an axial length of the expansion tool cylindrical part is ~~greater~~ no less than ~~or equal to~~ a length of a cylindrical part of a said shaping shoe, ~~which has a largest inner diameter.~~